

SHIP 22/11

Dart Aerospace Ltd.

Date: Monday, 20/11/2006 1:01:56 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ARM
<b>Job Number</b> : 29549	
<b>Estimate Number</b> : 10706	
<b>P.O. Number</b> :	<b>Part Number</b> : D2012103
<b>This Issue</b> : 20/11/2006 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2012 REV B2
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B2
<b>Previous Run</b> : 26662	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 22/11/2006 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev:1 02.04.03 Added Inspect level 3 NG	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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**Comment:** Qty.: 3.5700 f(s)/Unit Total : 7.1400 f(s)  
 Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)  
 Identify as D2012-101  
 Batch: 17102742

FF 06-11-21 2

2.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Punch to length as per Dwg D2012-103 &amp; template D2012-103T1(41.00")

FF 06-11-21 2

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Bend D2012-103 as per template D2012-103T2 &amp; Dwg D2012-103

FF 06-11-22 2

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

SB 06/11/22 (2)

5.0	POWDER COATING	POWDER COATING
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**Comment:** POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FC 06 11 22 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 20/11/2006 1:01:56 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 29549

Part Number: D2012103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FC 06 11 22 (2)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *SF 206*

*FC 06 11 22 (2)*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 06 11 22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

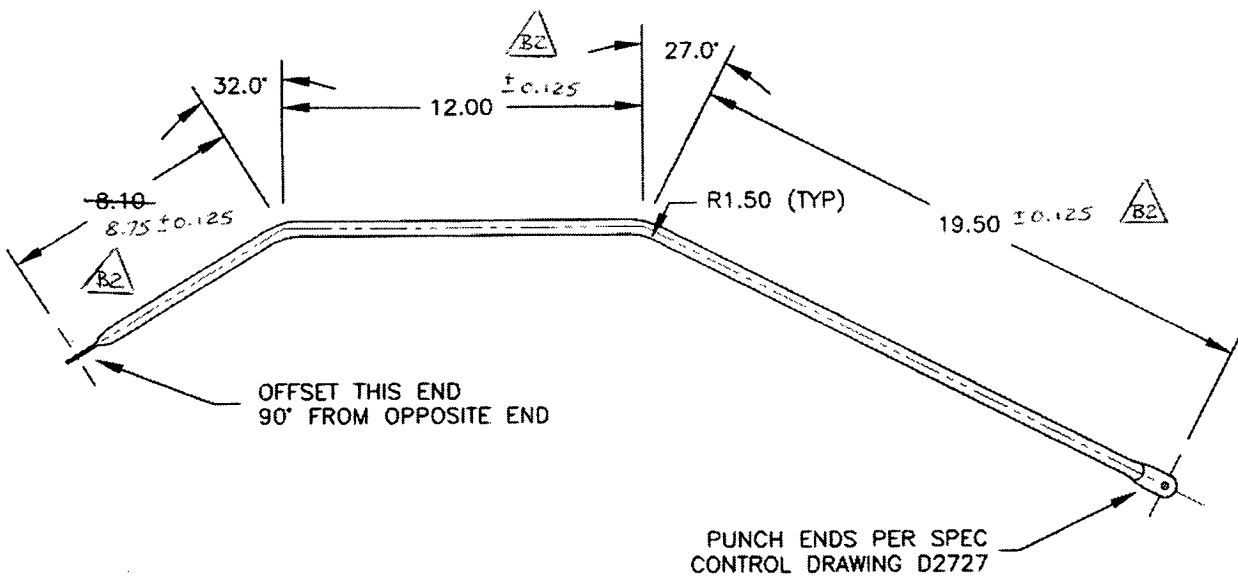
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART****RELEASED**  
98/05/05 KG

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. B
KE	KE		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
SMY	QJ	D2012-103	
DATE	TITLE	SCALE	
98.04.28	ARM	1:6	
A	92.06.08	NEW ISSUE	
B	98.04.28	CHANGE ANGLES (TSR A362)	
B1	02.05.25	ADD FINISH	
B2	05.04.27	ADD TOLERANCE, $\pm 0.125$ WALL $\pm 0.10$	

**NOTES:**

1. MAKE PER TEMPLATE DT8068 (WAS DT2012-103)
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE  $\phi 0.500 \times 0.035$  WALL
3. FINISH: POWDER COAT BLACK SANDTEX (4.35.7) PER DART QST 4.3

**REFERENCE ONLY**